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If no title is shown please refer to the description.  
Si aucun titre n'est indiqué se referer à la description.)

RECLOSABLE RIGID OR SEMI-RIGID CONTAINER AND PACKAGE MADE THEREFROM

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**Description****RECLOSABLE RIGID OR SEMI-RIGID CONTAINER AND PACKAGE MADE  
THEREFROM**

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**Technical Field**

[0001] The present invention relates to a rigid or semi-rigid container assembly and to the reclosable hermetically sealed package obtained therefrom.

**Background Art**

[0002] Hermetically sealed rigid or semi-rigid containers, such as trays with a flexible lid sealed around their edges, are widely used in the packaging of food products. This type of packaging offers several advantages: the rigidity of the container provides protection to the contents of the package during transportation, storage and handling, and the hermeticity of the seals contributes to the increase in the shelf-life of the product. In many cases the packaged product is not immediately consumed after opening of the package, forcing the consumer to time-consuming repackaging operations. A reclosable package would therefore be very convenient.

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[0003] Several attempts have been made in the past to provide reclosable rigid or semi-rigid packages. By way of example, EP-A-1,127,809 describes a food package comprising a container and a cover, said cover being formed by a peripheral clamping element and a lid sealed onto the peripheral clamping element. The lid and the peripheral clamping element are firstly joined

together, for instance by injection moulding the peripheral clamping element around the lid, and then joined to the container by sealing the lid to the flange of the container. Alternatively the peripheral clamping element is

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firstly sealed, welded or glued onto the flange of the container and then the lid is sealed onto the peripheral clamping element. In both cases two separate sealing steps, with two separate sealing tools, are required to hermetically seal the container.

[0004] As another example, FR 2,827,841 proposes the use of a composite cover for the closure of a packaging container comprising a peripheral frame whose central opening is closed with a film, whereby an easy-to-open seal is formed between the film and the rim of the packaging container. The packages described in the previous documents are easy to open and can be tightly reclosed due to the cooperation between the peripheral element and the rim of the container but share the disadvantage of requiring separate steps for their assembly, such as the separate assembly of the peripheral element and the film or the need for separate sealing operations, making the whole process cumbersome and costly.

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[0005] On the other hand FR 2,618,411 describes a package composed of a rigid single-piece container having a ring moulded around its flange and a film sealed onto both the ring and the flange of the container. To open the package the ring is broken away from the flange of the container and the film peeled away from the flange. However, once reclosed, the package of

this invention does not offer the required degree of reliability as there is no engagement between the frame and the flange of the container.

[0006] Therefore the need still exists for a rigid or semi-rigid container assembly

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which can be produced in a limited number of steps, which is hermetically sealed and which can be tightly and reliably reclosed after opening.

[0007] A first objective of the present invention is therefore to provide a rigid or semi-rigid container assembly for the packaging of food products which is reclosable and easy to use. Another objective is to provide a method of packaging a food product by means of the rigid or semi-rigid container assembly and a thermoplastic film sealed onto it to obtain a reclosable package. A further objective of the present invention is to provide a reclosable package comprising the rigid or semi-rigid container assembly, a product placed therein and a hermetically sealed lid in contact with the product.

#### **Disclosure of Invention"**

[0008] A first object of the present invention is a rigid or semi-rigid container assembly comprising a support and a frame, wherein the frame extends

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over a fraction of the periphery of the support leaving the central area of said support uncovered, and it is shaped to engage with the periphery of the support to form a releasable closure with the support .

[0009] A second object of the present invention is a method of packaging a food

product by means of the reclosable rigid or semi-rigid container assembly of the first object comprising the steps of: providing the container assembly with the frame engaged with the support and a product loaded onto the support, closing the container assembly by securing a thermoplastic film to the frame of the assembly and to at least part of the periphery of the support of the assembly not covered by the frame, wherein the seal to said periphery of the support extends in a continuous manner around said periphery to ensure hermeticity of the package.

[0010] A third object of the present invention is a reclosable package comprising the rigid or semi-rigid container assembly of the first object, a product loaded therein and a thermoplastic film laid over the product and in contact with it in at least one point and sealed to the support and to the frame of the assembly, wherein said film forms a first seal with the frame and a second, peelable seal with the support.

[0011] These and other objects, advantages, and features of the invention will be more readily understood and appreciated by reference to the detailed description of the invention and the drawings.

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### **Brief Description of Drawings**

[0012] Fig. 1 is a section of a container assembly according to one embodiment of the present invention in the closed state;

[0013] Fig. 2 is a section of the container assembly according to a second

embodiment of the present invention in the closed state;

[0014] Fig. 3 shows a further embodiment of the container assembly of the present invention shown in the closed state;

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[0015] Fig. 4 is a perspective view of the container assembly in the open state, where the flange of the support is provided with a tab and frame and support are connected by a hinge;

[0016] Fig. 5 is an enlargement of a package of the present invention in the closed state;

[0017] Fig. 6 is a schematic view of the sealing step of the packaging method according to the present invention;

[0018] Fig. 7 is a section of the package according to one embodiment of the present invention;

[0019] Fig. 8 is a section of the package according to a second embodiment of the present invention;

[0020] Fig. 9 is a perspective view of a package according to one embodiment of the present invention in the open state;

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[0021] Fig. 10 is a perspective view of a package according to one embodiment of the present invention in the open state.

### **Mode(s) for Carrying Out the Invention**

[0022] With reference to Fig. 1, which represents one embodiment of the rigid or

semi-rigid container assembly of the present invention in the closed state, container assembly 10 comprises a flat dish-like support 20 and a frame 30.

Flange 21 forms the periphery of support 20. Frame 30 includes a flat rim

32 and a skirt 31, which is shaped to engage with flange 21 of support 20

when the container assembly is in the closed state. When frame portion 30

is engaged with support 20, rim 32 of frame portion 30 covers only a

fraction of flange 21 of support 20 leaving a portion 22 of flange 21

uncovered. Frame 30 defines a central opening 35, so that, when container

assembly 10 is in the closed state, the central part 5 of support 20 remains

uncovered by frame 30 and products can be as easily loaded onto the

support as they would be onto any conventional container. When container

assembly 10 is in the closed state it is also possible to neatly stack one

assembly into the other, as generally done with tray-like containers. This

offers two major advantages: the container assemblies of the present

invention can be stored and shipped in a most space-efficient way and

once they arrive at the packaging facility they can be handled by

conventional loading equipment.

[0023] Fig. 2 shows a second embodiment of the container assembly of the

invention in the closed state comprising a tray-like support 120 and a frame

130. Support 120 comprises a flat bottom wall 124 and upwardly extending

side-walls 123 terminating in a horizontal outwardly extending flange 121,

which forms the periphery of support 120. In the embodiment shown in Fig.



2 frame 130 covers only the central portion of flange 121, leaving both the inner and the outer edges (122 and 122') of flange 121 uncovered as well as open mouth 105 of support 120 unhindered. Frame 130 engages with

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flange 121 by means of an interlocking groove-projection mechanism whereby projection 131 on frame 130 fits into groove 126 on flange 121.

The person skilled in the art recognizes that other alternative engagement mechanisms between frame 130 and flange 121 can be provided instead of the groove-projection mechanism.

[0024] Generally, frame 30 (130) of container assembly 10 (110) is a continuous construction, extending around the whole periphery of support 20 (120), as shown in Fig. 1-2. However in some instances it could be possible to have an incomplete frame 230 extending for example only over three sides of support 220, as shown in Fig. 3.

[0025] Container assembly 10 (110, 210) can have a rectangular (as shown in Fig. 1-3), elliptical, square, circular cross-section or any other desired shape. In the embodiment of the invention shown in Fig. 4 support 20 and frame 30 are connected by one hinge 40, although more than one hinge can be present. In a second embodiment of the invention, shown in Fig. 1-3, support 20 (120, 220) and frame 30 (130, 230) are not connected by any hinge. In Fig. 4 flange 21 is provided with tab 28 which can be grasped for separating the frame 30 from support 20.

[0026] Support 20 and frame 30 of the container assembly can either be made of

the same material or they can be made of different materials. Suitable materials for both the support and the frame are single layer or multi-layer thermoplastic materials, but other materials commonly employed in food packaging could be used, such as plastic coated paperboard or cardboard. In case of a single layer structure suitable thermoplastic materials are for instance polystyrene, polypropylene, polyesters, high density polyethylene, poly(phenylene oxide), poly(lactic acid), PVC and the like, either foamed or solid. In case of a multi-layer structure suitable materials are for instance ethylene homo- and co-polymers, propylene homo- and co-polymers, polyamides, polystyrene, polyesters, poly(lactic acid), PVC and the like. Part of the multi-layer structure can be solid and part can be foamed.

[0027] In one embodiment support 20 and frame 30 are made of the same multi-layer thermoplastic material comprising at least one substrate layer, one oxygen barrier layer and one heat-sealable surface layer. In a preferred aspect of said embodiment the substrate layer is of foamed polypropylene, polystyrene or polyester. The thickness of the substrate layer is typically comprised between 100 and 3,000  $\mu\text{m}$ , preferably between 300 and 1,000  $\mu\text{m}$ . The oxygen barrier layer comprises any of the polymers known in the art for their oxygen barrier properties, such as (ethylene-co-vinyl alcohol) copolymers, polyvinylidene chloride and polyamides. The thickness of the oxygen barrier layer will be set in order to provide the overall laminate with an Oxygen Transmission Rate (evaluated by following the method

described in ASTM D-3985 and using an OX-TRAN instrument by Mocon) at 23°C and 100% of relative humidity that it is lower than 250, preferably lower than 150 and even more preferably lower than  $100 \text{ cc}^3/\text{m}^2 \cdot \text{d} \cdot \text{atm}$ .

Typically when (ethylene-co-vinyl alcohol) copolymers and polyvinylidene chloride are used as the oxygen barrier materials this is achieved with barrier layers 3-8  $\mu\text{m}$  thick. The heat-sealable surface layer comprises materials chosen from the group of ethylene homo-and co-polymers, propylene homo- and co-polymers, ionomers and the like as well as blends of these polymers in any proportions. Suitable blends for the heat-sealable layer also include peelable blends. The thickness of the heat-sealable surface layer is typically comprised between 5 and 80  $\mu\text{m}$ , more preferably from about 8 to about 50  $\mu\text{m}$ . Additional layers can be present such as tie or adhesive layers, bulk layers and the like. In another embodiment the substrate layer of the multi-layer material is chosen from the group of polystyrene, polyesters, polypropylene, polyethylene, polyamide and the like.

[0028] Support 20 and frame 30 of the container assembly can be moulded by any technique known in the art, such as thermoforming, injection moulding, hot stamping, compression moulding and the like. They can be moulded either at the same time in a one-step operation starting from the same material or separately from the same or different materials.

[0029] A second object of the present invention is a method of packaging a food

product in the rigid or semi-rigid container assembly 10, comprising the steps of:

- providing container assembly 10 with frame 30 engaged with support 20, and a product 80 loaded therein;
- placing a web of thermoplastic film 60 over the container assembly 10 and product 80;
- optionally evacuating and /or gas flushing with a suitably selected purging gas or gas mixture the area between thermoplastic film 60 and support 20; and
- sealing film 60 over rim 32 of frame 30 and on the part 22 of flange 21 of the support 20 not covered by rim 32.

[0030] Container assembly 10 can be formed by engaging frame 30 onto support 20 after or, more preferably, before the product to be packaged is loaded onto the support. In the latter case this can be done right before the packaging operations take place or, more preferably, by the supplier of container assembly 10 at his own production facility.

[0031] In more details, container assembly 10 with frame 30 engaged with support 20 is placed in a container-like countersupport present in a suitable packaging machine. The product to be packaged is loaded into the container through the central opening 35 defined by frame 30 and through open mouth 5 of support 20. This can be done either manually or by means of a tray loading apparatus. A thermoplastic film 60 is then positioned over

container assembly 10 and product 80. Different types of thermoplastic films are known and may be suitably employed depending upon the product and the desired characteristics of the final package. Also depending on the

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nature of the product to be packaged it may be desirable to either create a vacuum or modify the atmosphere inside container assembly 10 before sealing thermoplastic film 60. The atmosphere can be modified either by simply flushing container assembly 10 with product 80 loaded therein with a suitable gas or gas mixture or by firstly evacuating it and then back-filling with a suitable gas or gas mixture. The gas or the gas mixture are selected to maximize the shelf-life of the product being packaged. Preferred gases to replace evacuated air include oxygen, carbon dioxide, nitrogen, argon and mixtures thereof. Once this step has been completed, thermoplastic film 60 is then sealed over container assembly 10. When the atmosphere inside the package is modified with respect to air or a vacuum has been created, thermoplastic film 60 is preferably chosen to have a low permeability to gases in order to maintain the atmosphere inside the package unchanged for the whole shelf-life of the product.

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[0032] In the method of the present invention, thermoplastic film 60 forms a first

seal 61 with rim 32 of frame 30 and a second, peelable seal 62 with part 22 of the flange of the support not covered by rim 32, as shown in Fig. 5.

Generally both seals 61 and 62 extend around the whole perimeter of rim 32 of frame 30 and of part 22 of flange 21, respectively. Alternatively, it is

preferred that at least seal 62 extends in a continuous manner around part 22 of flange 21 to ensure hermeticity of the package.

[0033] As used herein the term "peelable seal" refers to a seal which is strong

enough to guarantee the hermeticity of the package during its life-cycle but which can be easily opened by peeling apart by hand the two materials that were joined by the seal. The force required to peel the two layers away is usually referred to in terms of "peel force". A method of measuring the peel force is described in ASTM F-88-00. Acceptable peel force values for peelable seals usually range from 1,900 g/25 mm to 700 g/25 mm. The force required to peel thermoplastic film 60 from the container assembly at seal 61 can be comparable to, or preferably higher than the force required to peel thermoplastic film 60 from the container assembly at seal 62.

[0034] In one embodiment of the method of the present invention seal 61 is a

permanent seal, that is a seal that can not be opened without causing the physical destruction of at least one of the materials joined by the seal.

Several methods can be employed to form a permanent seal 61 and a peelable seal 62 between thermoplastic film 60 and container assembly 10.

For instance, support 20 and frame 30 of container assembly 10 could be made of the same multi-layer thermoplastic laminate, which comprises at least two layers, indicated in Fig. 5 as 101 and 102, of different materials. The support 20 will have an innermost food contact layer 101 and an outermost layer 102. The frame 30, of the same laminate, will be positioned

with layer 101 in contact with layer 101 of support 20 and with layer 102 facing thermoplastic film 60. The heat-sealable surface layer of thermoplastic film 60 will then be suitably chosen to form a permanent seal with the outer layer 102 of frame 30 and a peelable seal with the inner heat-sealable layer 101 of support 20.

[0035] Alternatively, the area 22 of the flange of support 20 not covered by rim 32 could be embossed so that, regardless of the compatibility between the sealing surface of film 60 and the inner heat-sealable layer of container assembly 10, the seal in the roughened surface could be easily openable.

[0036] In still another method the sealing frame of the packaging machine could be formed by two separate concentric frames: the frame sealing thermoplastic film 60 onto rim 32 of frame 30 operating at a temperature and/or pressure selected to produce a strong seal 61 and the frame sealing thermoplastic film 60 onto the area of the flange 22 not covered by rim 32 operating at a lower temperature and/or pressure, therefore making a weaker, easy to open seal 62.

[0037] Thermoplastic film 60, generally in sheet or web form, may be a single layer or a multi-layer structure. In the latter case the various layers may be bonded together by any conventional and suitable method, e.g. coextrusion, extrusion coating, lamination etc. In case of a single layer structure suitable polymeric materials are for instance ethylene homo- and co-polymers, propylene homo- and co-polymers, ionomers, polyamides,

polyesters, polystyrene, poly(lactic acid) and the like. In case of a multi-layer structure suitable materials for the layer that will be sealed to the container assembly (the heat-sealable layer) are as indicated above. In

both cases to obtain hermetic seals thermoplastic film 60 or its heat-sealable layer, in case of a multi-layer structure, must be selected to have a certain degree of chemical compatibility with the surface of container assembly 10. Film 60 can be either oriented or non-oriented and in the former case it can be either heat-shrinkable or non heat-shrinkable. In one embodiment of the present invention thermoplastic film 60 is substantially impermeable to oxygen, that is it has an Oxygen Transmission Rate (evaluated by following the method described in ASTM D-3985 and using an OX-TRAN instrument by Mocon) at 23°C and 0% of relative humidity that is lower than 200, preferably lower than 150 and even more preferably lower than  $80 \text{ cc}^3/\text{m}^2 \cdot \text{d} \cdot \text{atm}$ . This can be achieved by using a polymeric material which has oxygen barrier properties such as (ethylene-co-vinyl alcohol) copolymers, polyvinylidene chloride and polyamides.

[0038] In a first preferred embodiment of the present invention the packaging

method comprises the steps of:

- providing container assembly 10 with the frame 30 engaged with support 20;
- placing a product 80 in the container through the central opening 35



defined by frame 30 and through open mouth 5 of support 20;

- placing a web of oriented heat-shrinkable thermoplastic film 60 over the container assembly 10 and product 80;
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- optionally evacuating and /or gas flushing with a suitably selected purging gas or gas mixture the area between thermoplastic film 60 and support 20;
  - sealing film 60 on rim 32 of frame 30 and on part 22 of the flange of support 20 not covered by rim 32; and
  - subjecting thermoplastic film 60 to a sufficiently high temperature to shrink said film.

[0039] Preferably support 20 (120) of container assembly 10 (110) is in the form of a shallow tray, wherein the term "shallow tray" is used to indicate a tray having a depth, that is a distance between flange 21 (121) and bottom wall 24 (124) of the tray, comprised between 0 and 20 mm. Support 20 (120) is generally made of foamed thermoplastic material, such as foamed polystyrene, foamed polypropylene or foamed polyester, optionally laminated to an oxygen impermeable material. Frame 30 (130) can be made either of the same material as support 20 (120) or of a different material, for instance rigid polyethylene.

[0040] Oriented heat-shrinkable film 60 generally comprises at least one heat-sealable surface layer, one oxygen barrier layer and one outer heat-resistant layer, wherein the outer heat-resistant layer is made, for

instance, from materials chosen from the group of polypropylene, polyethylene, polyesters and polyamides.

[0041] The packaging method of the invention can be performed on currently

available tray lidding machines, either automatic or manual, commercially supplied by, e.g., Ross Industries, Inc., Multivac, Inc. or Mondini S.p.A. with only minor modifications. Specific examples of suitable models include the Multivac® T550 or the Mondini Evoluzione Super. In this type of machines sealing of the thermoplastic film onto the sealing surface of the support is carried out by means of a sealing frame, which forms a continuous seal around the perimeter of the sealing surface of the support. Sealing can be accomplished by any method known in the art, for instance by hot-bar, impulse, RF etc. In one embodiment of the present invention, shown in Fig. 6, the sealing section of sealing frame 70 is at least as wide as the flange 21 of support 20, so that a continuous seal can be formed between the thermoplastic film and both the rim 32 of frame 30 and the part 22 of the flange of support 20 not covered by rim 32. The sealing section of sealing frame 70 can have a flat profile with square edges, as shown in Fig. 6, or any other suitable profile, such as flat with rounded edges, step-like etc. As an alternative, sealing frame 70 can be formed by two separate concentric frames: one for sealing thermoplastic film 60 onto rim 32 of frame 30 and one for sealing thermoplastic film 60 onto part 22 of the flange of support 20 not covered by rim 32. Thermoplastic film 60 may be cut to the desired size

at any time, prior to, during or after it is sealed to container assembly 10, forming film portion 63 which is secured to the assembly by means of seals 61 and 62. In a preferred method cutting is accomplished immediately after sealing by means of a cutting frame which encircles sealing frame 70, or by means of a heated knife. Shrinking of thermoplastic film 60 can be accomplished either by means of hot water or, preferably, by means of hot air.

[0042] In a second preferred embodiment of the present invention the packaging method comprises the steps of:

- providing container assembly 10 with the frame 30 engaged with support 20;
- placing a product 80 in the container through the central opening 35 defined by frame 30 and through open mouth 5 of support 20;
- placing a web thermoplastic film 60 over the container assembly 10 and product 80;
- heating thermoplastic film 60;
- evacuating the area between thermoplastic film 60 and support 20;
- draping thermoplastic film 60 over product 80; and
- sealing thermoplastic film 60 over support 20 and frame 30.

[0043] As shown in Fig. 7, at the end of the packaging process thermoplastic film 60 forms a tight skin around product 80. Thermoplastic film 60 forms a peelable seal 62 with the area of support 120 not covered either by product

80 and by frame 130 and it forms a seal 61 with rim 132 of frame 130.

Several methods can be employed to form peelable seal 62. For instance support 120 could be made from a multi-layer structure comprising a thin

heat-sealable food-contact layer adjacent to a layer consisting of a blend of resins having a low cohesive strength. Blends with low cohesive strength that can be used are for instance those described in WO99/54398. An alternative method could be to select the heat-sealable layers of both thermoplastic film 60 and support 120 to obtain a peelable seal. Suitable combination of heat-sealable layers are for instance those described in WO 02/62575.

[0044] Generally both support 20 and thermoplastic film 60 comprise at least one layer of an oxygen impermeable material. Preferably support 20 is made of a rigid or semi-rigid multi-layer film which can be easily thermoformed. Frame 30 can be made either of the same material as support 20 or of a different one. When frame 30 is made of the same material as support 20 selective opening, that is peeling of seal 62 between thermoplastic film 60 and support 20 and keeping of seal 61 between frame 30 and thermoplastic film 60, is possible because of the lower stress to which seal 61 is subjected when the package is opened. Thermoplastic film 60 is generally a non-oriented material with good formability.

[0045] The packaging method of the invention could be performed on currently available Vacuum Skin Packaging (VSP) machines, like the Multivac®

CD6000 machine, by introducing minor modifications. In this type of machines a first web of material is thermoformed into the support part of the package, then the product is loaded and the supported product is advanced to a vacuum chamber where the top film is heated and then sealed to the support under vacuum. According to one possible modification of such process, after thermoforming of support 20 and before loading of product 80, separately produced frame 30 could be engaged onto support 20. According to another possible modification container assemblies 10 with frame 30 engaged onto support 20 could be fed directly to the product loading section of a VSP machine, by replacing the thermoforming section of the machine with a conventional tray loading apparatus.

[0046] A third object of the present invention is a rigid or semi-rigid reclosable package obtained from container assembly 10, product 80 and thermoplastic film 60. With reference to Fig. 7 and 8, which represent two embodiments of the package of the present invention, package 90 comprises a rigid or semi-rigid container assembly 10 (110), comprising support 20 (120) and frame 30 (130) engaged with support 20 (120), a ~~product 80 loaded therein and a thermoplastic film 60 in contact with~~ product 80 in at least one point and sealed onto rim 32 (132) of frame 30 (130) and on part 22 (122) of the flange of support 20 (120) not covered by rim 32 (132). Thermoplastic film 60 forms a first seal 61 with rim 32 (132) of frame 30 (130) and a peelable seal 62 with part 22 (122) of the flange of

support 20 (120) not covered by rim 32 (132) of frame 30 (130).

[0047] Package 90 can be opened by disengaging frame 30 from flange 21, peeling seal 62 open and lifting frame 30 away from support 20. As shown

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in Fig. 9, once peelable seal 62 has been opened, portion 63 of thermoplastic film 60 remains secured to frame 30 by means of seal 61 thus forming a unitary, self-standing lid 45. Lid 45 can be used to reclose package 90, providing optimal storage conditions for product 80 even after the package has been opened.

[0048] Fig. 10 represents a further embodiment of the package of the invention wherein frame 230 extends only around three sides of support 220. When opened, lid 245 is lifted from support 220 only on the three sides of the frame and remains joined to support 220 along the fourth side 250.

[0049] The container assembly of the invention offers a simple and economical solution to the problem of providing rigid or semi-rigid reclosable containers. In fact, by simply sealing a thermoplastic film over the container assembly of the invention, it is possible to obtain a package which is hermetically sealed during the distribution and sale cycle, that can be easily opened and

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that can be repeatedly reclosed. As a further advantage the container assembly of the invention can be handled with the same equipment used for conventional tray-like containers without the need of major modifications.

**Claims**

1. A rigid or semi-rigid container assembly (10, 110, 210) comprising a support (20, 120, 220) and a frame (30, 130, 230) wherein the support (20, 120, 220) comprises a peripheral flange (21, 121, 221) outwardly extending from the support (20, 120, 220), and the frame (30, 130, 230), comprising a rim (32, 132, 232) and optionally a skirt (31, 131, 231), is shaped at its edge to cooperate with the flange (21, 121, 221) to be releasably secured onto the support (20, 120, 220) when the container assembly (10, 110, 210) is in the closed state, characterized in that the rim (32, 132, 232) of the frame (30, 130, 230) extends only over a fraction of the flange (21, 121, 221), thus leaving the central area (5, 105, 205) of the support (20, 120, 220) and the remaining part (22, 122, 222) of the flange (21, 121, 221) not covered by the rim (32, 132, 232) of the frame (30, 130, 230).
2. The container assembly (10, 110, 210) according to claim 1 wherein the support (20, 120, 220) is flat.
3. The container assembly (10, 110) according to claim 1 or 2 wherein the frame (30, 130) extends around the whole perimeter of the support (20, 120).
4. The container assembly (210) according to claim 1 or 2 wherein the frame (230) extends around a portion of the perimeter of the support (220).
5. The container assembly (10, 110, 210) according to any one of claims 1 to 4 wherein said assembly consists of one or more layers of a thermoplastic

material chosen from the group comprising polyolefins, polyamides, polyesters, polystyrene, PVC, poly(lactic acid).

**6. A method of packaging a food product in a rigid or semi-rigid container**

assembly comprising the steps of: providing a container assembly (10, 110, 210) according to any one of claims 1 to 5 with the frame (30, 130, 230) engaged with the support (20, 120, 220) and a product (80) loaded therein; placing a thermoplastic film (60) over the container assembly (10, 110, 210) and the product (80); optionally evacuating and /or gas flushing with a suitably selected purging gas or gas mixture the area between the thermoplastic film (60) and the support (20, 120, 220); and sealing the thermoplastic film (60) on the rim (32, 132, 232) of the frame (30, 130, 230) of the assembly and on the part (22, 122, 222) of the flange of the support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130, 230).

**7. The method of packaging of claim 6 further comprising the step of subjecting the thermoplastic film (60) to a sufficiently high temperature to shrink said film after the sealing step is completed.**

**8. The method of packaging according to claim 6 or 7 wherein the**

thermoplastic film (60) forms a permanent seal (61) with the rim (32, 132, 232) of the frame (30, 130, 230) of the container assembly (10, 110, 210) and a peelable seal (62) with the part (22, 122, 222) of the flange of the support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130,



230).

9. The method of packaging of claim 6 further comprising the steps of heating the thermoplastic film (60) before evacuating the area between the thermoplastic film (60) and the support (20, 120, 220); then, after the evacuation step is completed, draping the thermoplastic film (60) over the product (80); and sealing the thermoplastic film (60) on the rim (32, 132, 232) of the frame (30, 130, 230) and on the whole area of support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130, 230) and the product (80).
10. The method of packaging according to claim 9 wherein the thermoplastic film (60) forms a permanent seal (61) with the rim (32, 132, 232) of the frame (30, 130, 230) of the container assembly (10, 110, 210) and a peelable seal (62) with the part of the support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130, 230) and the product (80).
11. A package (90) comprising a rigid or semi-rigid container assembly (10, 110, 210) according to claim 1, a product (80) placed therein and a thermoplastic film (60) sealed on the rim (32, 132, 232) of the frame (30, 130, 230) and on the part (22, 122, 222) of the flange of the support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130, 230), characterized in that the thermoplastic film (60) contacts the product (80) in at least one point.

12. The package according to claim 11 wherein the thermoplastic film (60) forms a permanent seal (61) with the rim (32, 132, 232) of the frame (30, 130, 230) and a peelable seal (62) with the part (22, 122, 222) of the flange of the support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130, 230).
13. The package according to claim 11 wherein the thermoplastic film (60) forms a permanent seal (61) with the rim (32, 132, 232) of the frame (30, 130, 230) and a peelable seal (62) with the part of the support (20, 120, 220) not covered by the rim (32, 132, 232) of the frame (30, 130, 230) and the product (80).

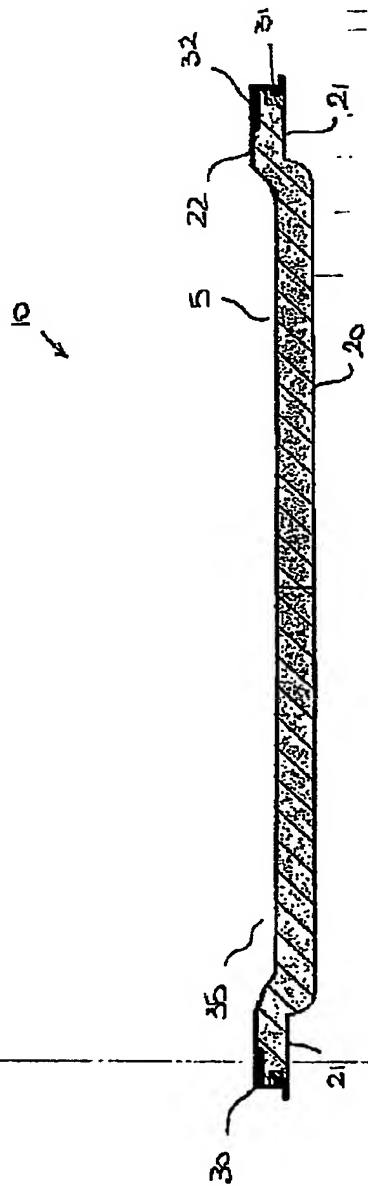


Fig: 1

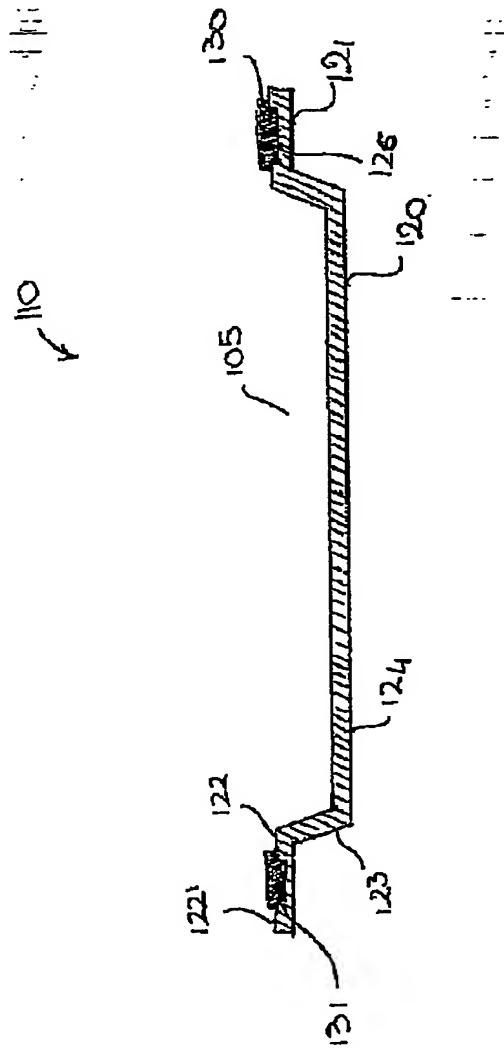


Fig: 2

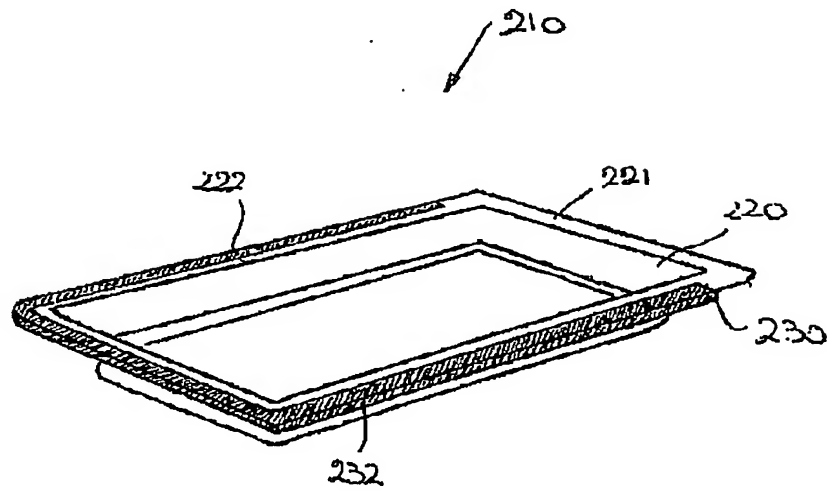
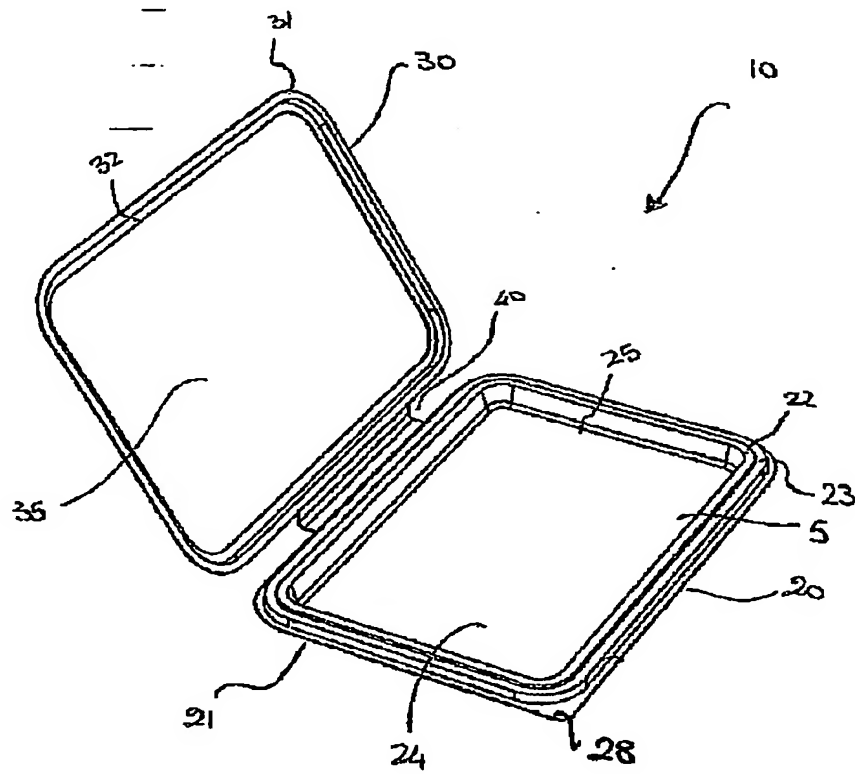


Fig: 3



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**Fig: 5**

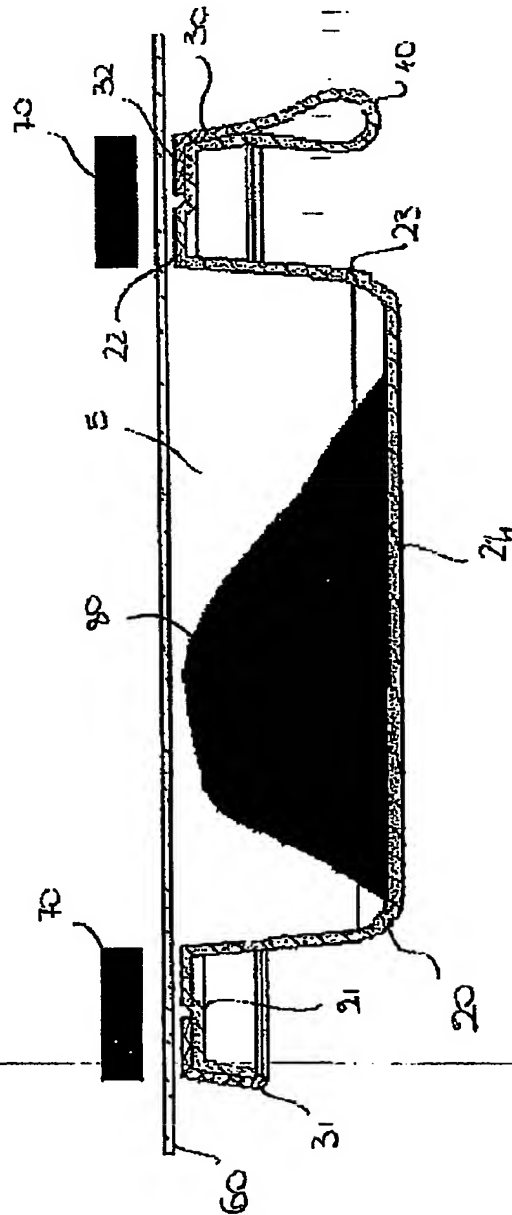
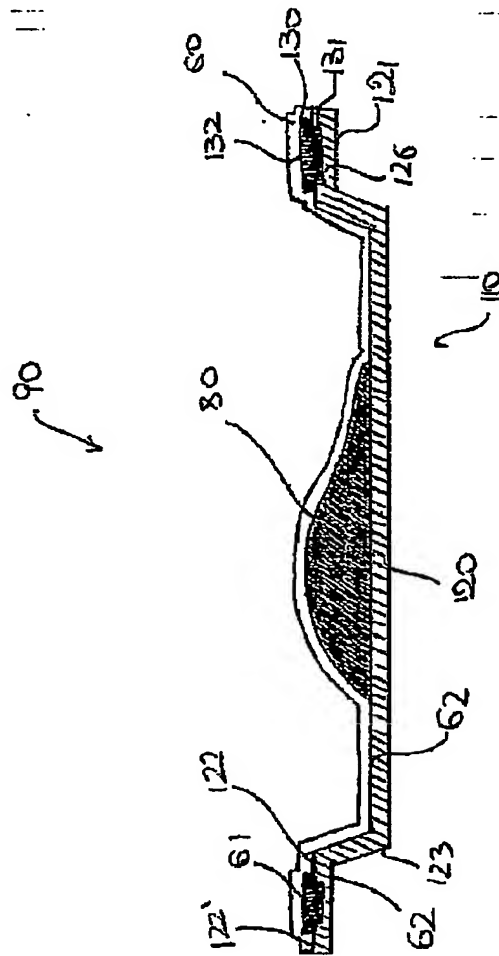




Fig: 6



Year	1960	1961	1962	1963
1. Total	100.0	100.0	100.0	100.0
2. Federal	10.0	10.0	10.0	10.0
3. State	20.0	20.0	20.0	20.0
4. Local	70.0	70.0	70.0	70.0
5. Other	0.0	0.0	0.0	0.0
6. Total	100.0	100.0	100.0	100.0
7. Federal	10.0	10.0	10.0	10.0
8. State	20.0	20.0	20.0	20.0
9. Local	70.0	70.0	70.0	70.0
10. Other	0.0	0.0	0.0	0.0

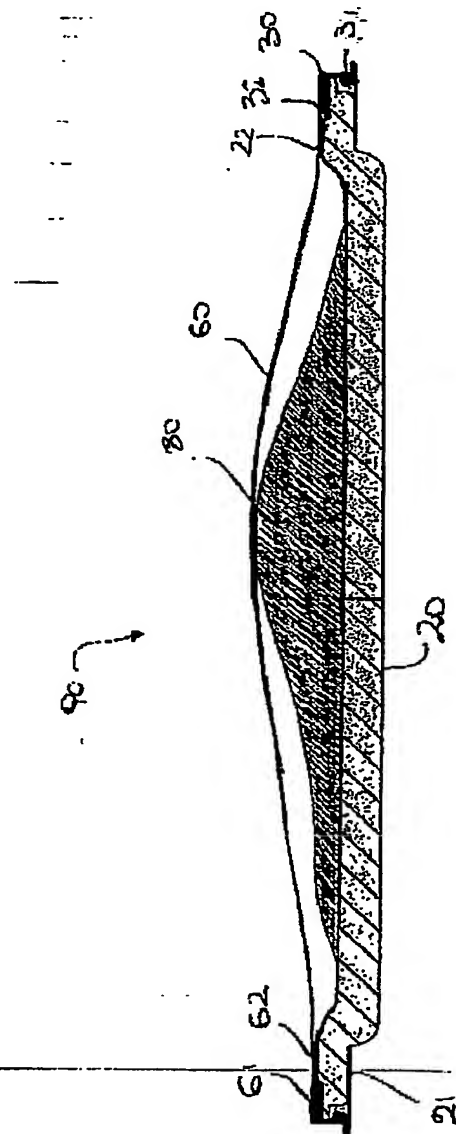


Fig: 8

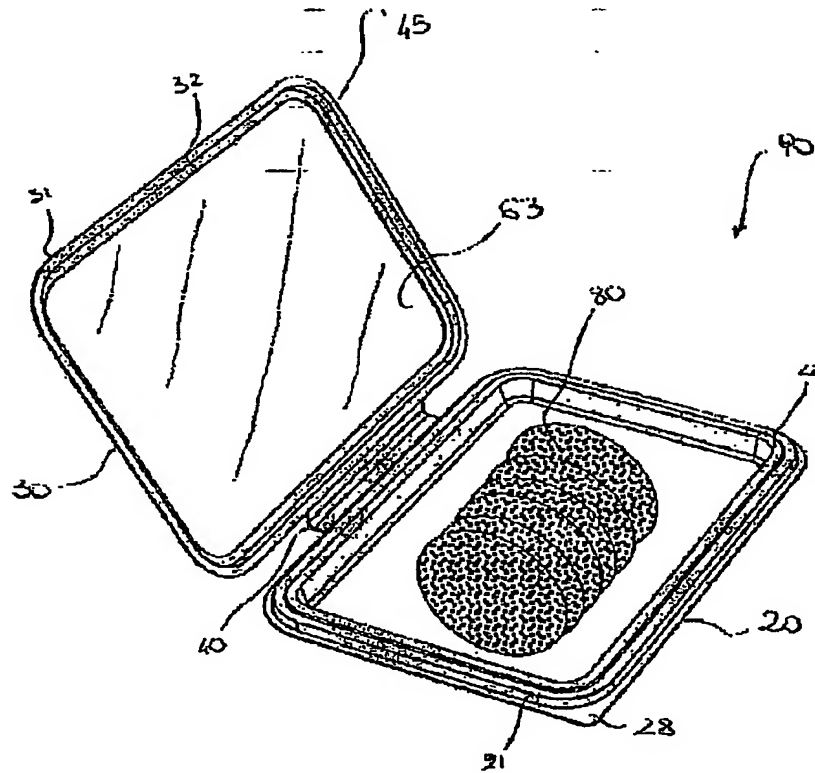


Fig: 9

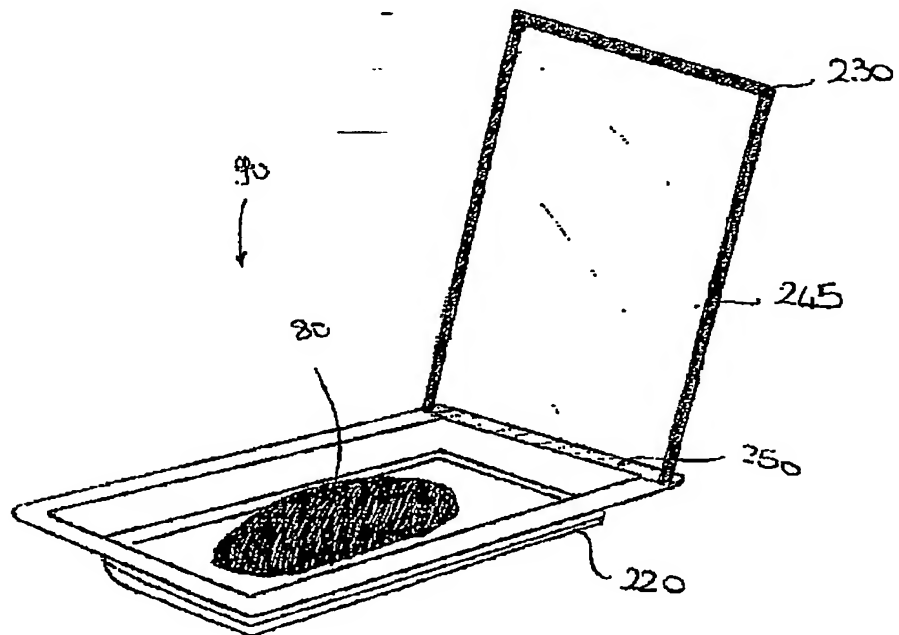


Fig: 10

**Abstract**

There is described a rigid or semi-rigid container assembly 10 (110, 210) for the packaging of food products. The container assembly 10 (110, 210) comprises a

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support 20 (120, 220) and a frame 30 (130, 230). Support 20 (120, 220) comprises an outwardly extending peripheral flange 21 (121, 221) which is shaped to cooperate with frame 30 (130, 230) so that the frame can be snap-fit closed onto support 20 (120, 220). The rim 32 (132, 232) of frame 30 (130, 230) extends only over a fraction of flange 21 (121, 221) leaving part 22 (122, 222) of the flange and the central part (5, 105, 205) of support 20 (120, 220) uncovered.

Also described is a method of packaging a food product and a package obtained by sealing a thermoplastic film 60 on the rim 32 (132, 232) of frame 30 (130, 230) and on part 22 (122, 222) of the flange of support 20 (120, 220) not covered by the rim 32 (132, 232) of the frame 30 (130, 230), wherein the film forms a first seal 61 with the rim 32 (132, 232) of the frame 30 (130, 230) and a peelable 62 seal with part 22 (122, 222) of the flange of support 20 (120, 220) not covered by the rim 32 (132, 232) of the frame 30 (130, 230).

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